

Date: Wednesday, 9/26/2007 7:56:05 AM
User: Kim Johnston

Process Sheet

SPLIT

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE BILLET
Job Number : 34874 <i>D</i>	
Estimate Number : 10034	
P.O. Number :	Part Number : D6101005
This Issue : 9/26/2007 S.O. No. :	Drawing Number : D6101 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 31388	Material :
Written By : <i>[Signature]</i>	Due Date : 10/26/2007 Qty: 300 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est. A. 01.05.04 New Issue EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *4685*

a) Description: Aluminum billet

b) 5.00" x 8.250" x 2.50" thick

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 5.00" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

C207109124

(300)

2.0 D6101005P 7075-T7351 8.25X5.0X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 300.0000 Each(s)
7075-T7351 8.25X5.0X2.5

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

AS 687/31 100
08/07/24

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

counter
S06207/31 (2100)

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Drawing Name: SADDLE BILLET

Job Number: 34874

Part Number: D6101005

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Handwritten: 2/2 08/08/07

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Handwritten: 100

Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 08/05/08

Job Completion



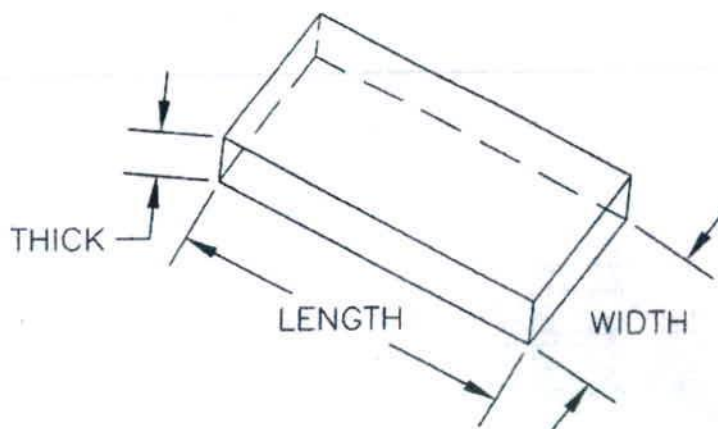
Handwritten: MF 08-08-05



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED S	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34874

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

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REQUISITION CLIENT-CUSTOMER REQUISITION NO.		NO. COM. CLIENT-CUST. ORD. NO.		COMPTÉ-ACCT	VEND. SLS	TERR.	EXPÉDIE PAR-SHIP VIA	NO. FEVILE/EMBALLAGE-B/L NUMBER	
AETEUR-PURCHASING AGENT		TELEPHONE	H/C	TAX	7	COMORD	REGION LIVRAISON-DEL ZONE	F.A.B.-F.O.B.	BILL

RE A-SHIP TO:	VENDU A-SOLD TO:	INFORMATION CRÉDIT-CREDIT INFORMATION
INSTRUCTIONS/LIVRAISON-DELIVERY	INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)	INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)

SCRIPTION - ITEM 1	QTE/UNITE COM.-ORDERED	PCES/PCOM-ORD	POIDS COM.-WT. ORDERED
2.5000 PLATE 7075-T7351 ALUM 8.00" X 5.00"	100 PCS	PCS	1042
BLACK W/RED STRIPE	BALLOTS-BUNDLES	PCES/PCD EXP. SHP.	POIDS EXP.-WT. SHIPPED
	3	100	1042
CERTIFICATE OF CONFORMANCE	COULÉE INFO-HEAT INFO QTE-QTY		FORME-SHAPE I.A.C.
A.M. Castle & Co. certifies that the material(s) supplied under this document will meet and conform to the specifications of the product(s) described hereon. A.M. Castle & Co. (Canada) Inc.	436539 A1		6879
WEIGHT FOR SHIPPING PURPOSES ONLY. SEE INVOICES FOR ACCURATE BILLING WEIGHT. PLEASE SIGN AND DATE DRIVER'S COPY FOR RECEIPT OF MATERIAL AND, IF CHECKED, TEST REPORTS.	INSTRUCTIONS (CONT'D.)		ENT-W
	100 X 8.25" X 5.00"		N3

SCRIPTION - ITEM 2	QTE/UNITE COM.-ORDERED	PCES/PCOM-ORD	POIDS COM.-WT. ORDERED
2.5000 PLATE 7075-T7351 ALUM 8.25" X 7.75"	100 PCS	PCS	1615
BLACK W/RED STRIPE	BALLOTS-BUNDLES	PCES/PCD EXP. SHP.	POIDS EXP.-WT. SHIPPED
	2	100	1615
TERMS AND CONDITIONS OF SALE	COULÉE INFO-HEAT INFO QTE-QTY		FORME-SHAPE I.A.C.
SEE DISCLAIMERS AND LIMITATIONS ON THE REVERSE SIDE	436534 A1		6879
	INSTRUCTIONS (CONT'D.)		ENT-W
	100 X 8.25" X 7.75"		N3

SCRIPTION - ITEM 3	QTE/UNITE COM.-ORDERED	PCES/PCOM-ORD	POIDS COM.-WT. ORDERED
	BALLOTS-BUNDLES	PCES/PCD EXP. SHP.	POIDS EXP.-WT. SHIPPED
ALL EXCEPTIONS FOR SHORTAGE OR DAMAGE MUST BE NOTED ON THE DRIVER COPY & CUSTOMER COPY OF THE DELIVERY RECEIPTS & SIGNED BY THE DRIVER & CUSTOMER. COPY OF SUCH RECEIPT PROPERLY NOTED MUST BE SUBMITTED WITHIN 10 DAYS WHEN CREDIT IS REQUESTED.	COULÉE INFO-HEAT INFO QTE-QTY		FORME-SHAPE I.A.C.
NOM (LETTRE MOULÉE)-NAME (PRINT ONLY)	INSTRUCTIONS (CONT'D.)		ENT-W
RECU PAR-RECEIVED BY			
DATE RECU-DATE RECEIVED			

SHIP TO:
A M CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

**KAISER
ALUMINUM**
Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4122744

SOLD TO:
AM CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

CUSTOMER PO NUMBER: 01-42198		WORK PACKAGE:		CUSTOMER PART NUMBER: 6879 A97075-60		SHIP RUN/LOAD ID: 101230/11		GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1061984	LINE ITEM: 1	SHIP DATE: 28-FEB-2008	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: MILL FINISH PLATE			
WEIGHT SHIPPED: 3596 LB	QUANTITY: 2 PCS EST.	B/L NUMBER: 2016662	GAUGE: 2.5000 IN		WIDTH: 48.500 IN	LENGTH: 144.500 IN			

Certified Specifications

AMS 4078/RevG
ASTM B 209/Rev07
BSS 7055/RevA
DPS 4.713/RevAH
GSS16100/RevG

AMS-QQ-A-250/12
ASTM B 594/Rev06
CMMP 025/RevR
EAC MS1011/RevE
MMS 159/RevN

AMS-STD-2154
BAC 5439/RevH
CSTI 006/RevC
GAMPS 9101/RevB
PS 21211/RevK

Test Code: 4297

Test Results

Lot: 436539A1 Cast 149

Drop 39

Ingot 4

(ASTM B8/B55Z)

Tensile: T7351
Temper

Dir / # Tests
LT / 2 (Min:Max)

Ultimate KSI (MPA)
71.0 : 71.5
(490 : 493)

Yield KSI (MPA)
59.6 : 61.2
(411 : 422)

Elongation %
10.3 : 10.6

(ASTM E1004)

Conductivity %IACS :
(MS/M) :

41.1 Min
23.8 Min

41.5 Max
24.1 Max

(ASTM E1251)

Chemistry:
Actual

SI
0.10

FE
0.22

CU
1.5

MN
0.02

MG
2.5

CR
0.20

ZN
5.7

TI
0.03

V
0.01

ZR
0.01

TOT

OTHER
0.03

CASTLE METALS CORP.
DATE RCVD 3/4/08
IAC 6879
APPROVED BY

**KAISER
ALUMINUM**

Troutwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4122744

Lot: 435673A8 Cast 145

Drop 38

Ingot 3

(ASTM E8/B557)

Tensile Temper
T 351Dir / # Tests
T 2 (Min:Max)Ultimate KSI (MPA)
71.0 : 71.3
(490 : 492)Yield KSI (MPA)
59.8 : 60.0
(412 : 414)Elongation %
10.4 : 10.4

(ASTM E1004)

Conductivity %IACS :
(MS/M) :41.0 Min
23.8 Min41.2 Max
23.9 Max

(ASTM E1251)

Chemistry:

Actual

SI
0.10FE
0.22CU
1.4MN
0.02MG
2.5CR
0.21ZN
5.9TI
0.02V
0.01ZR
0.01

TOT

OTHER
0.03**ALLOY LIMITS**

Chemistry:

7075 MIN

MAX

SI
0.00
0.10FE
0.00
0.50CU
1.2
2.0MN
0.00
0.30MG
2.1
2.9CR
0.18
0.28ZN
5.1
6.1TI
0.00
0.20V
0.00
0.05ZR
0.00
0.05OTHER
EACH
TOTMAX
0.05
0.15**Aluminum Remainder****TEST NOTES**

Metal represented by this test report was immersion
ultrasonically tested from one side and meets the Class A
and Class B requirements of all specifications referenced
on this test report.

CERTIFICATION

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE U.S.A OR CANADA AND
MANUFACTURED IN THE U.S.A AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS
INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD
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WITHOUT THE WRITTEN APPROVAL OF ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDS OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS
ON ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR

Bill Poy

